Tuesday, 5/23/2006 8:36:18 AM

€ User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 27204A

Estimate Number

: 10338

P.O. Number

: NIA

This Issue

: 5/23/2006

Prsht Rev. First Issue

Previous Run

Written By

Comment

: NC

: NIA : 26801

S.O. No. : MIA

Type

: PURCHASED PARTS

Drawing Name : LUG

Part Number

: D2657 : D2657 REV A

Drawing Number Project Number

: N/A

Drawing Revision

Material Due Date AIM: : 6/10/2006

30 Um:

Each

Additional Product

Checked & Approved By

Job Number:



Seq. #:

Machine Or Operation:

Description:

M1010B0750X02500 1.0

ASTM A21 Steel .75"x2.5"



Comment: Qty.:

0.1925 f(s)/Unit Total: 5.7740 f(s)

Material: ASTM A36 steel bar 2.50" x 0.75" thick

(M1010-B0.750 x 02.500)

Batch MINO 28

J.F. 06/05/25

30

2.0

BAND SAW

BAND SAW

Comment: BAND SAW

Cut blanks: 2.200" long

Comment: HAAS CNC VERTICAL MACHINING #1

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1





1-Machine per folio FA040 and Dwg D2657

2-Deburr

30

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

30

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS

3C

H:\forms\Quality Assurance\approved forms\NCRWO revC

W/O:			W	ORK C	RDER CH	ANGES	3				
DATE	STEP	PR	OCEDURE CH	ANGE			Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		•									
			······································								
NCR:			WORK ORD	DER NO	ON-CONFO	RMAN	CE (NCF	2)		 	
		Description of NC		Corre	ctive Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	A	ction Descrip Design Mgr	tion	Sign & Date		tion C	Design Mgr	QC Inspector
						•					
US MANY											
					İ						
							,				
),						
Part No);	PAR #:	Fault Catego	ory:		NCR:	Yes (No)	DQA:	D	Date: △(/05/3/
	ate & initial						QA: N/C CI				

Date:

Tuesday, 5/23/2006 8:36:18 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27204A

Part Number: D2657

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:			V	VORK ORDER CH	ANGES				
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date Q	Approval Mfg / Design Mgr	Approval QC Inspector
	:		•						
							· · · · · · · · · · · · · · · · · · ·		
NCR:			WORK OR	DER NON-CONFO	RMANO	CE (NCR)		
DATE	STEP	Description of NC		Corrective Action			Verificati	on Approval	Approval
DAIL	SIEP	Section A	Initial Design Mgr	Action Descript Design Mgr	tion	Sign & Date	Section C		QC Inspector
,			,						
								~ ·	·
		,							
				,		·			
,									
Part No):	PAR #:	Fault Categ	ory:	NCR: Y	'es No	DQA:	Date:	·
NOTE: D	ate & initi	al all entries				A: N/C CI	osed:	Date:	

H:\forms\Quality Assurance\approved forms\NCRWO revC

DART AEROSPACE LTD	Work Order:	27204A
Description: Lug	Part Number:	D2657
Description: Lug		
Inspection Dwg: D2657 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

•	X	First Arti	cle	Prot	otype	
Drawing	T-1	Actual	Accent	Poinct	Method	

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	10.0.0.00	Dimension			Inspection	
0.375	+/-0.010	375"				
1.20	+/-0.030	1. 199"				
0.060	+/-0.010	",o\$5"				
R1.68	+/-0.010	BLOB"				
0.510	+/-0.010	508 Ø				
R0.65	+/-0.030	B.648"				
1.92	+/-0.030	1,920"				
	. 1					
	•					
				•		
				,		
				_		
		1				
		-				

				<u></u>
Measured by: T.F.	Audited by:	51	Prototype Approval:	N/A
Date: 06/05/06	Date:	06.05.26	Date:	NIA

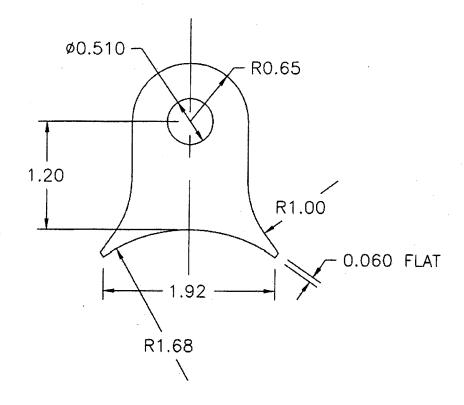
Rev	Date	Change	<i>9</i> •	<u> </u>	Revised by	Approved
A C	03.12.23	New Issue		· · · · · · · · · · · · · · · · · · ·	KJ/RF	





DESIGN	ORAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPR VED	DRAWING NO. REV. A
	A	D2657 SHEET 1 OF 1
DATE		TITLE . SCALE
 97.11.03		LUG 1:1
Α	97.11.03	NEW ISSUE

RELEASED (17/11/07 DS)



0.063

BREAK ALL SHARP CORNERS 0.010-T0-0.020
MATERIAL: ASTM A36 STEEL 0.375 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER—LINE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WINDERST TO AMENDMENT

Copyright 1997 by DART AEROSPACE LTD

WORK OF DERY A